

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015817**Date Inspected:** 19-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay # 04, Deck Panel

QA inspector performed conventional Ultrasonic Testing (UT) Inspection of approximately 10% for Lack of Penetration (LOP) on deck panel weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Deck Panels. The weld designations reviewed are as follows.

DP3099-001-001~006, 138~141, 173, 174, 176~181

DP3106B-001-001~006, 138~141, 173, 174, 176~181

DP3105-001-001~006, 138~141, 173, 174, 176~181

DP3100-001-001~008, 229~244

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 04, DECK PANEL REPAIR

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

13BE-DP3092-001

During random in process inspection this QA inspector observed that ZPMC personnel were performing repair welding on the Partial Joint Penetration (PJP) weld joints of deck panel 13BE-DP3092-001. Welder is identified as 062265. ZPMC CWI is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-Repair. The repair area details are as follows.

Weld: 005; Y location: 4450

Weld: 007; Y location: 2150, 2750

Weld: 009; Y location: 450

Weld: 171; Y location: 550, 3550

Weld: 175; Y location: 3550

Weld: 180; Y location: 50

Deck Panel Repair

This QA inspector observed that ZPMC NDT personnels were performing Magnetic Particle Testing (MT) after root pass on the repair locations of weld joint of deck panel. The weld designations reviewed are as follows.

13BE-DP3093-001 (5 Locations)

13CE-DP3102-001 (4 Locations)

13BE-DP3092-001 (13 Locations)

13CE-DP3104-001 (7 Locations)

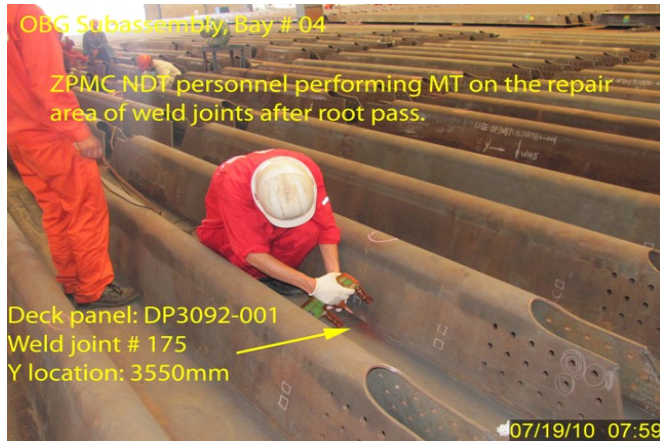
13BE-DP3087-001 (7 Locations)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
